
PRASA PROJECT


APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION


This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 
				TC1	M4	M1	M2	M3	TC2		
<input checked="" type="checkbox"/> DTR3000152647	AAD0001413329	CARBODYSHELL M2 ASSEMBLY	CB1210				<input checked="" type="checkbox"/>			PRA,CB1210,DTR313744 97/3.V25	YES
<input type="checkbox"/>											

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba	12/12/2018
			CHECKER	Nosizo Pindela	12/12/2018
			REVISED BY	Ramokone Motama	12/12/2018
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi Collins	21/02/2022
			CHECKER	Andani Muthelo	21/02/2022
			REVISED BY	Andani Muthelo	21/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	14/04/2023
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Zwane Ntokozo	27/07/2023
			REVISED BY	Mohlampe Amogelang	27/07/2023
28	07/11/2023	Addition of welder traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	07/11/2023
			REVISED BY	Ntokozo Zwane	07/11/2023

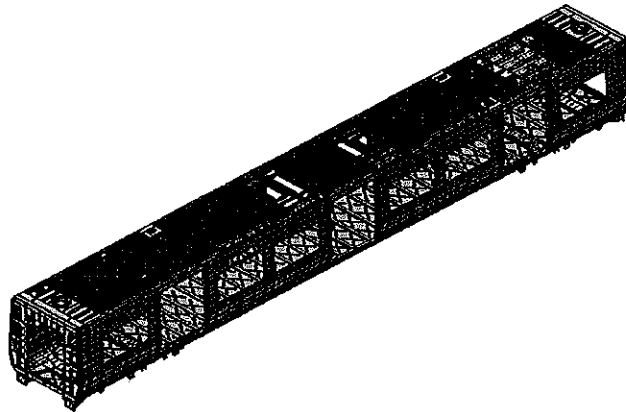
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
T3223	M2	P. MALATJI 405960	20/05/2024	SI.CB1210.247.V28	17

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		Date 07/11/2023	

Car: M2	NCR:	Work station: CB1210
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Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	A	S	L	U					
DTR31374497/3			X				VDS			N/A	20/05/24

I.2 - Instruments Control

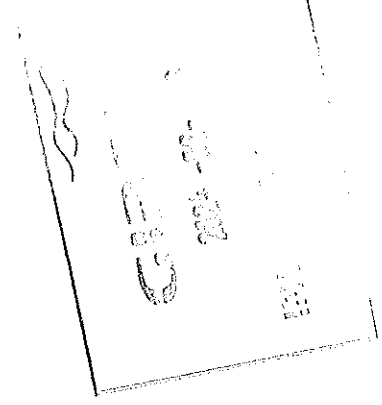
Monitoring and Measuring Instrument Control - Used for Special Process


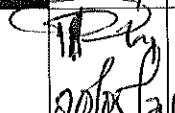

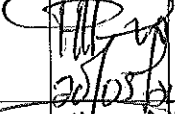

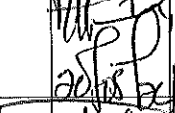



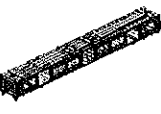
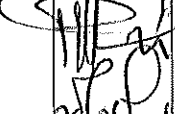

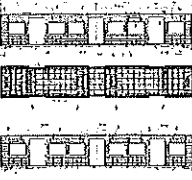



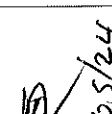
Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
LUBRICAR	30828-0	15/05/25	✓		
LASER TAPE	125428904	08/01/25	✓		
SOM TAPE	01870102	18/11/24	✓		

1.3 - Consumables


Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSI	314018-74097	11 G	✓		
ER 308 L	249687-70302	11 G	✓		



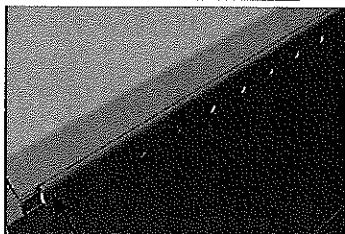
		CARBODYSHELL M2 ASSEMBLY DTR31374497/3		Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.247.V28		
II - Self Inspection - Items to Check							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	AA00001375051	✓		 20/05/24	 20/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD00000210675	✓		 20/05/24	 20/05/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD00000210675	✓		 20/05/24	 20/05/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 20/05/24	 20/05/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 20/05/24	 20/05/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		 20/05/24	 20/05/24
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		 20/05/24	 20/05/24

20/05/24
 INDUSTRIAL
 20/05/24

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		Date 07/11/2023	

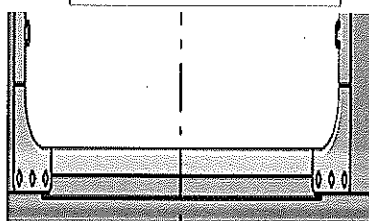
Welder traceability

Roof ring welds



<p style="text-align: center;"><u>LHS</u></p>	
Boiler maker (Name & Sign): <u>PONTBOO [Signature]</u>	Welder (Name & Sign): <u>MITHOKOZIS [Signature]</u>
<p style="text-align: center;"><u>RHS</u></p>	
Boiler maker (Name & Sign): <u>PONTBOO [Signature]</u>	Welder (Name & Sign): <u>MITHOKOZIS [Signature]</u>

Door ring welds



LHS

Boiler maker (Name & Sign): Tim [Signature]

Welder (Name & Sign): Thabang [Signature]

RHS


Boiler maker (Name & Sign): Tim [Signature]

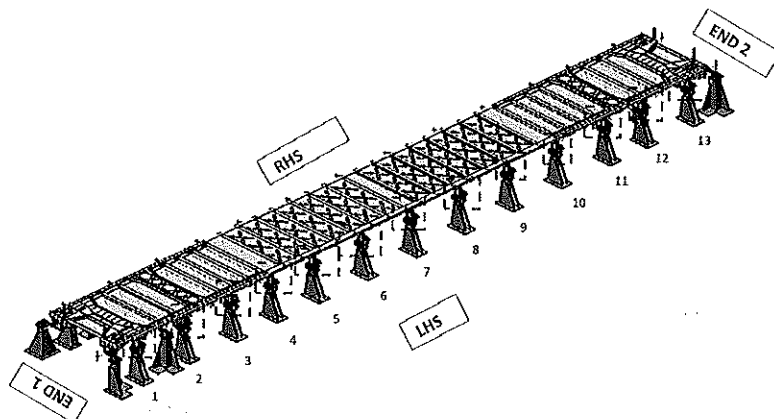
Welder (Name & Sign): Thabang [Signature]

OPERATOR:

ERATOR: SIPHOKAZI Ph.

2024-08-08
INDUSTRIAL GROUP
MANAGEMENT

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		Date 07/11/2023	
		Specifications of Details for CBS measurement	



Measure gap between Jlg pillar / chair and underframe = 0mm. No

After loading and clamping

Fill in the gap found on each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	1	0	0	0	1	1	0	0	0	0
Right Hand Side	0	0	0	0	0	0	1	0	0	0	0	0	0

Signature Operations:

Date:

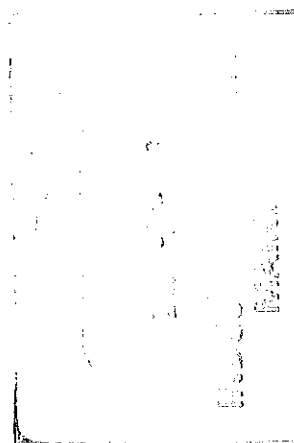
After Welding.

Fill in the gap found each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Industrial Quality:

Date:





CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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28

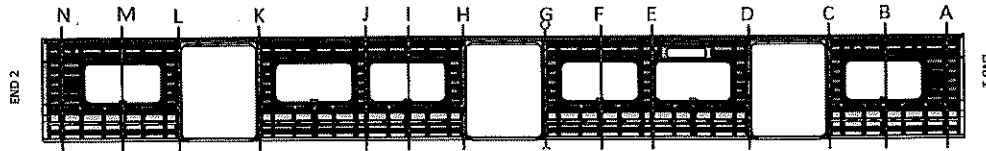
Date

07/11/2023

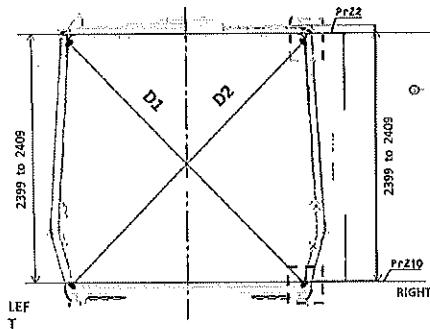
Project: PRASA

SI.CB1210.247.V28

Specifications of Details for CBS measurement



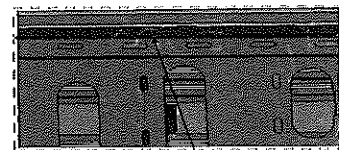
9



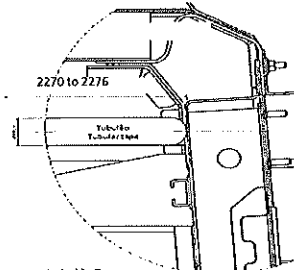
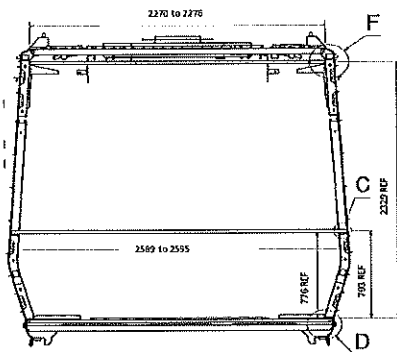
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.

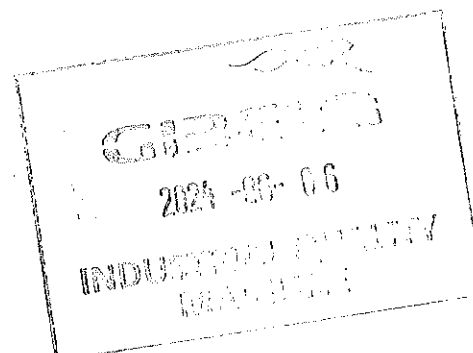



Reinforcement area measurement positions on roof reinforcement area.



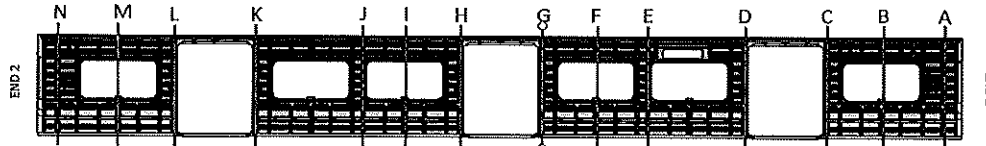
Detail F

Don't considering the reinforcement



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		Specifications of Details for CBS measurement	

BEFORE WELDING




Note: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3067	3068	1	2400	2404	0
B	3070	3070	0	2405	2404	1
C	3066	3067	3	2406	2405	1
D	3067	3067	0	2404	2404	0
E	3067	3068	1	2404	2406	2
F	3067	3068	1	2404	2405	1
G	3067	3067	0	2404	2404	0
H	3068	3066	2	2405	2404	1
I	3069	3068	1	2406	2404	2
J	3067	3068	1	2403	2404	1
K	3069	3068	1	2405	2405	0
L	3068	3068	0	2404	2403	1
M	3067	3068	1	2404	2406	2
N	3071	3071	0	2406	2404	2

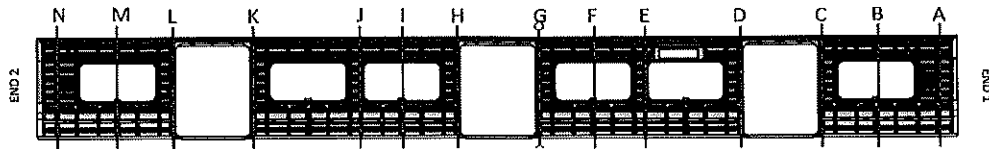
409060
20 105 04

409060
20 105 04

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
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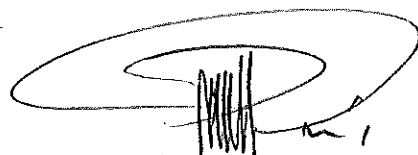
Specifications of Details for CBS measurement


AFTER WELDING



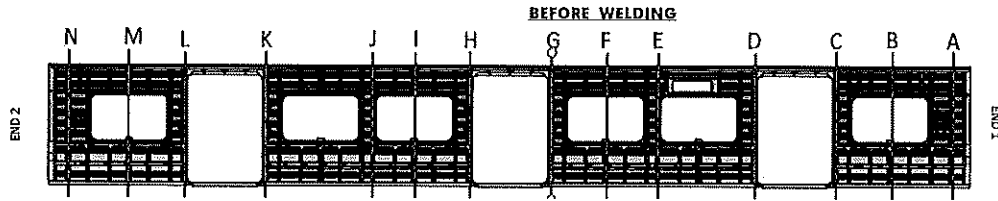
Note: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3298	2	2404	2404	0
B	3269	3267	2	2405	2404	1
C	3296	3298	2	2406	2404	2
D	3299	3298	1	2404	2405	1
E	3269	3268	1	2404	2406	2
F	3267	3267	0	2404	2404	0
G	3298	3299	1	2406	2404	2
H	3297	3298	1	2405	2404	1
I	3267	3269	2	2403	2404	1
J	3268	3269	1	2404	2404	0
K	3296	3296	0	2404	2405	1
L	3297	3298	1	2404	2406	2
M	3266	3266	0	2403	2403	0
N	3297	3298	1	2405	2404	1


 32996
 2405
 2024-05-26
 2024-05-26
 2024-05-26

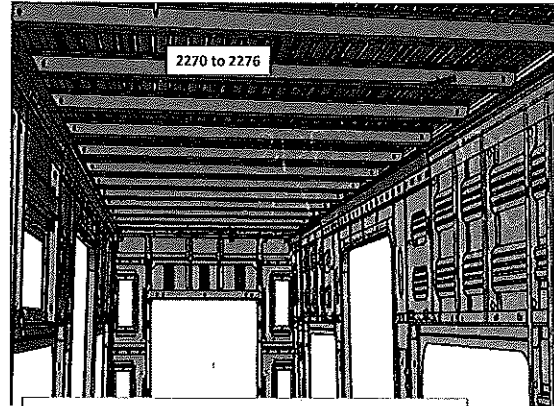
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.247.V28
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CBS measurement



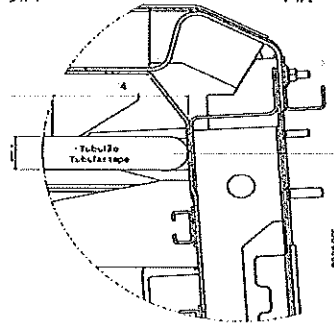
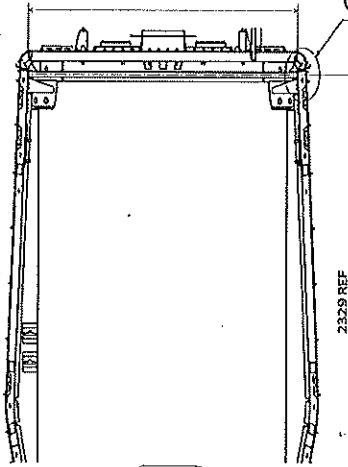
2270 to 2276

A	2270
B	2271
C	2272
D	2273
E	2274
F	2275
G	2276
H	2277
I	2278
J	2279
K	2280
L	2281
M	2282
N	2283



Do not consider reinforcement (Take measurements top area of zee profile


2265 to 2271

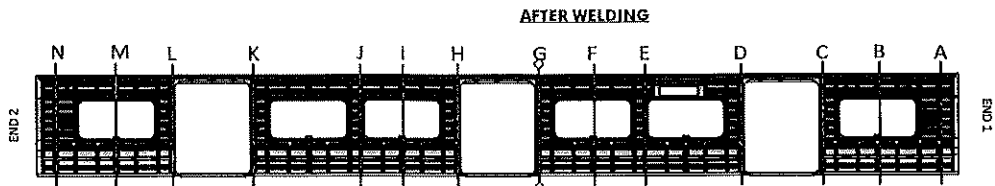


Detail G

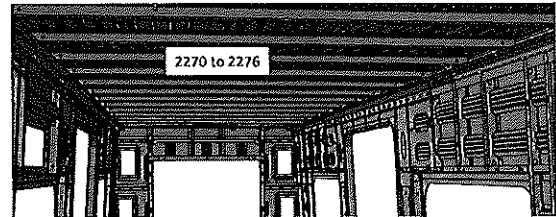
Considering the reinforcement plate

2265 to 2271
4099/60
2010/10

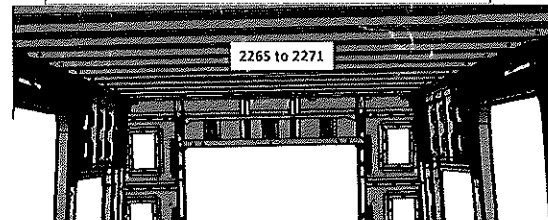
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
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CBS measurement			



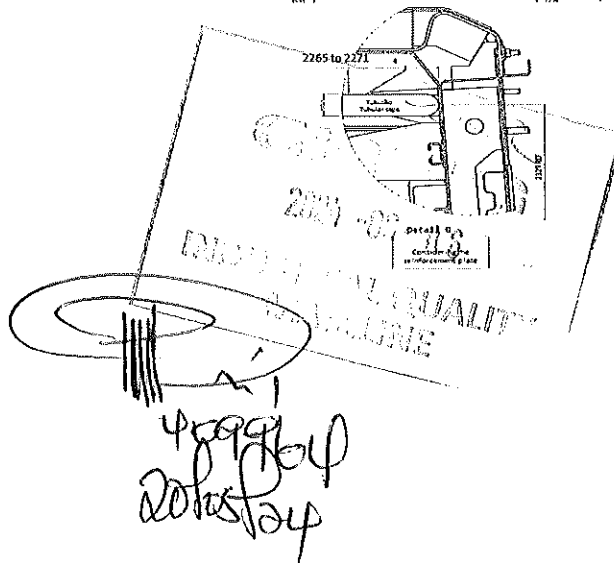
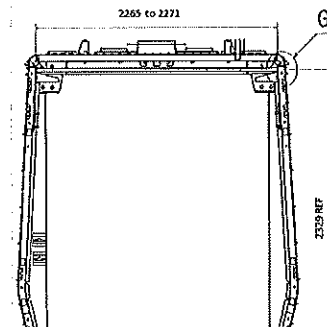
	2265 to 2271	2270 to 2276
A	2269	
B		2274
C	2267	
D	2268	
E		2276
F		2275
G	2268	
H	2269	
I		2276
J		2274
K	2270	
L	2270	
M		2274
N	2267	



Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)





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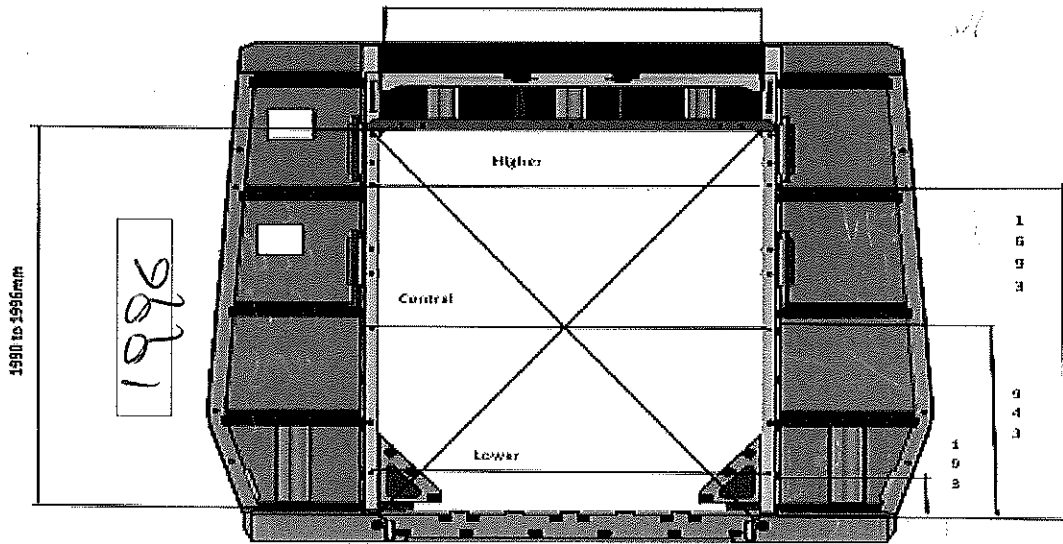
Date

07/11/2023

CBS measurement

End frame 1

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1881

D1

24/6

Central Dimension

1380

D2

24/6

Lower Dimension

1381

D1-D2

0

Handwritten signature and date: 20/05/24

Handwritten text: 16.06.2024, 14:00, 14:00



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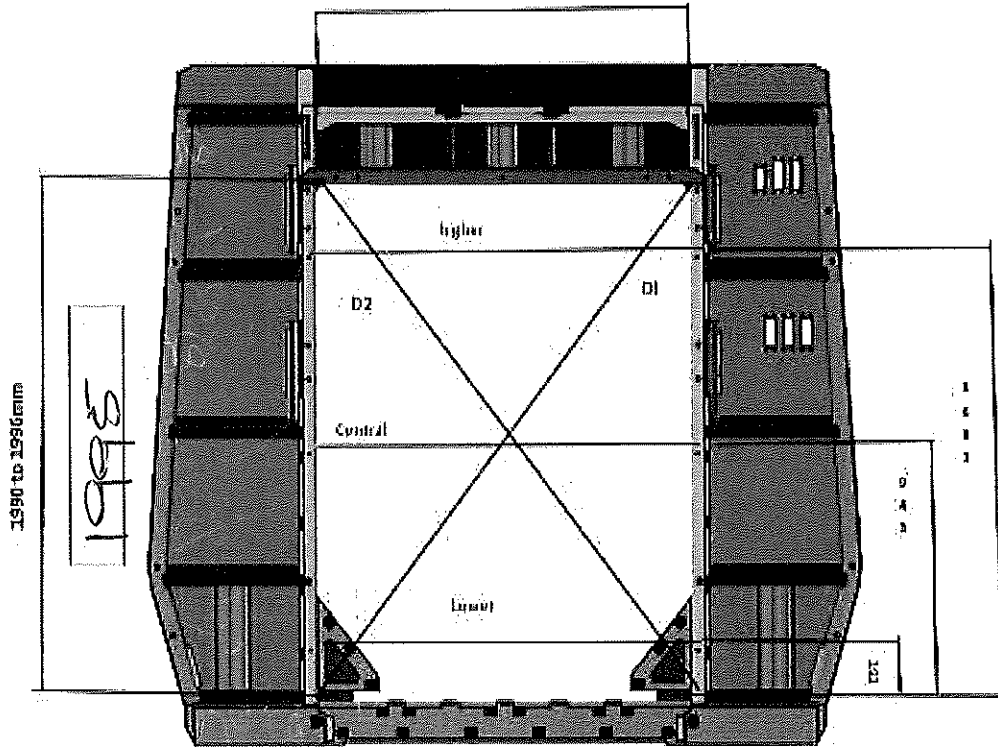
Date

07/11/2023

Project: PRASA

SI.CB1210.247.V28

End frame 2



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1380

D1

2415

Central Dimension

1380

D2

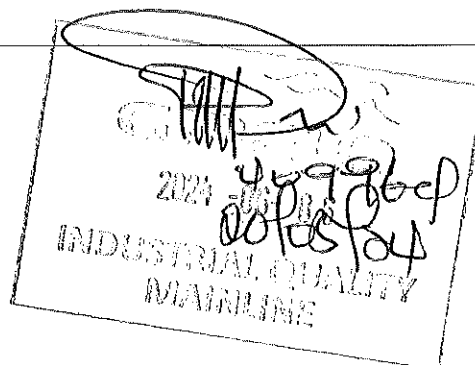
2416

Lower Dimension

1381

D1-D2

1



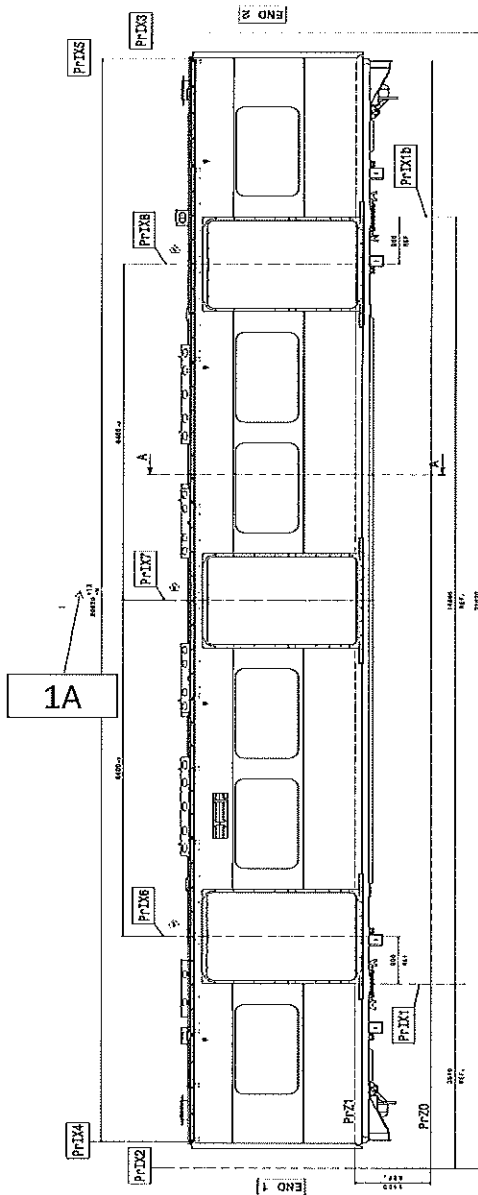


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07/11/2023

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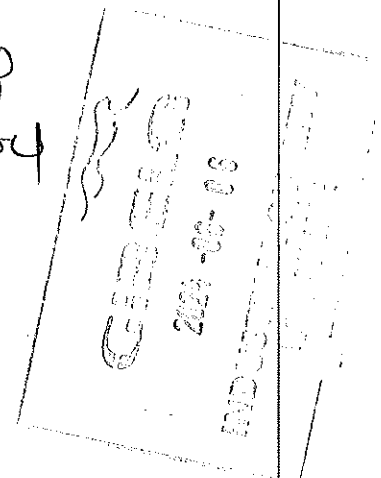
Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616



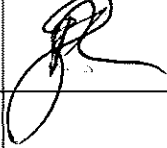
Handwritten signature and notes:
407768
20616
20614



Dye penetrant test

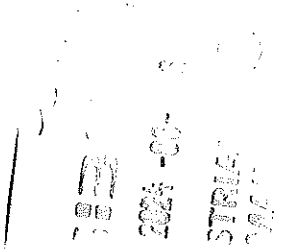
Dye-penetration test to be performed by quality personnel

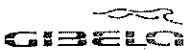
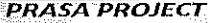



		CARBODYSHELL M2 ASSEMBLY DTR31374497/3		Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.247.V28	
Self Inspection - Final Result						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(if activities are not complete, the missing activities must not impact the next stage!)	20/05/24	Ton Bo		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	20/05/24	Ntobeko		
	NO GO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality	
In case of "NO GO", describe blocking problems						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description		Responsible	Due date	Status	

Operations

Quality


2024-06-07
STB16



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1



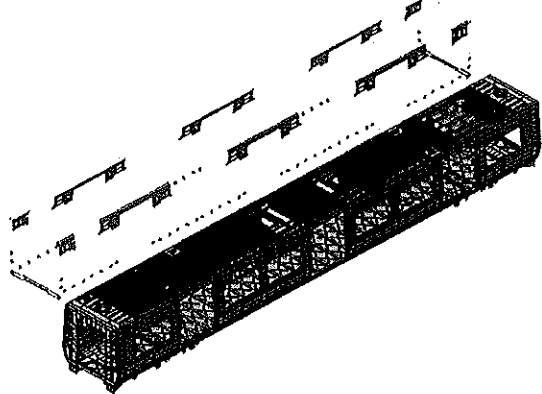





SELF INSPECTION SHEET

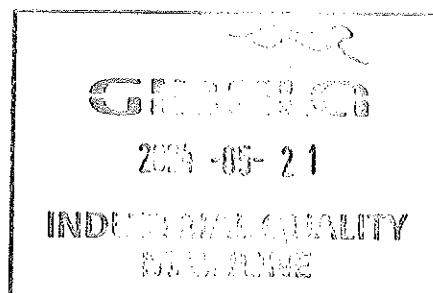
CONFIDENTIAL INFORMATION
This document and the information contemplated therein have to be considered as Confidential information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

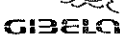



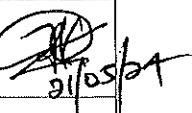

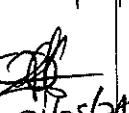


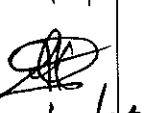
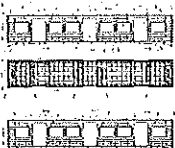


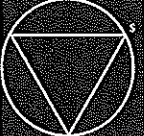

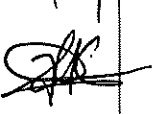
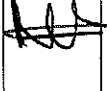
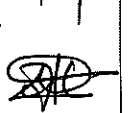
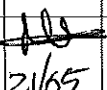
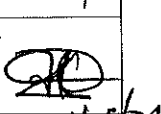
APPLICATION REFERENCE												
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY 1	
				TCL	M4	M1	M2	M3	TCL			
<input type="checkbox"/>	DIR3000152655	AAD00001433319	CARBODYSHELL P2 ASSEMBLY	CB1220					X		PRA.CB1220.DTR31374497 /2.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
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<input type="checkbox"/>												
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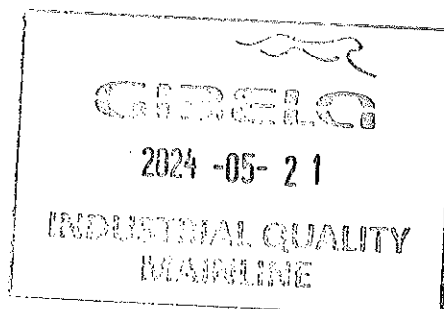
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	01/02/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	01/02/2018
			CHECKER	Nosizo Pindela	01/02/2018
			COMPILER	Thanyani Mathegu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	18/05/2018
			CHECKER	Nosizo Pindela	18/05/2018
			REVISED BY	Ramokone Mphahlele	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB1210	APPROVER	Itumeleng Modiba	2018/07/05
			CHECKER	Nosizo Pindela	2018/07/05
			REVISED BY	Ramokone Mphahlele	2018/07/05
3	2018/06/12	Width tolerance as per DT0000336500	APPROVER	Itumeleng Modiba	2018/06/12
			CHECKER	Nosizo Pindela	2018/06/12
			REVISED BY	Nosizo Pindela	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
7	27/05/2019	Removed measurement positions on the display windows	APPROVER	Itumeleng Modiba	27/05/2019
			CHECKER	Nosizo Pindela	27/05/2019
			REVISED BY	Nosizo Pindela	27/05/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISED BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mufaudzi	17/08/2021
			REVISED BY	Mpho Mufaudzi	17/08/2021
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			REVISED BY	Andani Muthelo	20/02/2022
26	14/06/2022	Update Minimum temperature requirement for sealant application	APPROVER	Mbhombi collins	14/06/2022
			CHECKER	Andani Muthelo	14/06/2022
			REVISED BY	Andani Muthelo	14/06/2022
27	19/10/2022	Addition of traceability for sealant application and welding.	APPROVER	Mbhombi collins	19/10/2022
			CHECKER	Ntokozo Zwane	19/10/2022
			REVISED BY	Amogelang Mohlampe	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	14/04/2023
			REVISED BY	Amogelang Mohlampe	14/04/2023
29	28/10/2023	Addition of bracket quantity	APPROVER	Tyson Hgobeni	28/10/2023
			CHECKER	Kelebone Mathapo	28/10/2023
			REVISED BY	Amogelang Mohlampe	28/10/2023


TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
228	Mo2	Tebelo	21/05/24	SI.CB1220.276.V29	15

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA													
		20														
		Date	SI.CB1220.276.V29													
		28/10/2023														
Car: M2	HCR:	Work station:	CB1220													
 Safety Related																
																
I - Documentation and Instruments Control																
L1 - Documentation Control																
Document	Type of car	Revision	Observation	OK												
DTR31374497/2	<table border="1"> <tr> <td>P</td> <td>A</td> <td>S</td> <td>E</td> <td>S</td> <td>O</td> </tr> <tr> <td></td> <td></td> <td></td> <td>✓</td> <td></td> <td></td> </tr> </table>	P	A	S	E	S	O				✓			29	21/08/24	✓
P	A	S	E	S	O											
			✓													
Signature/Date (Manufacturing)  21/05/24 Signature/Date (Quality)  21/05/24																
L2 - Instruments Control																
Monitoring and Measuring Instrument Control - Used for Special Process																
Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Quality)												
Measuring tape	12/04/25	12/04/25	✓	 21/05/24												
Turbular	32825-2	18/03/25	✓	 21/05/24												
1.3 Consumables																
Welding Consumable Control - Used for Special Process																
Filler Material	Heat Number	Welding Process	OK	Signature/Date (Quality)												
Welding wire	223067	MIG Welding	✓	 21/05/24												

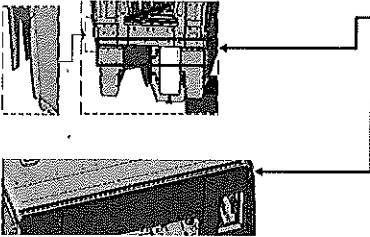


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA			
		29				
		Date	SI.CB1220.276.V29			
		28/10/2023				
II - Self Inspection - Items to Check						
II.1 - Items to check						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRACB1220 DTR31374497/2 Verification of flange for all reinforcement brackets.	PRACB1220 DTR31374497/2	✓	 21/05	 21/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210575	✓	 21/05	 21/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	 21/05	 21/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	 21/05	 21/05/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	 21/05	 21/05/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-016. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-016 and DTD0000210658.	✓	 21/05	 21/05/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Sherbondy Temperature Min - Max (°C) Min - Max 10°C - 35°C Relative Humidity Min - Max (RH) Min - Max 25% - 65%	Sealant Batch: <u>B32447</u> Exp Date: <u>01/06/24</u> Actuals Temperature: <u>21</u> Humidity: <u>28</u>	✓	 21/05	 21/05/24
08	NA	Verification of sealant application in certain regions in the drawing	AAD0001433329	✓	 21/05	 21/05/24





	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	

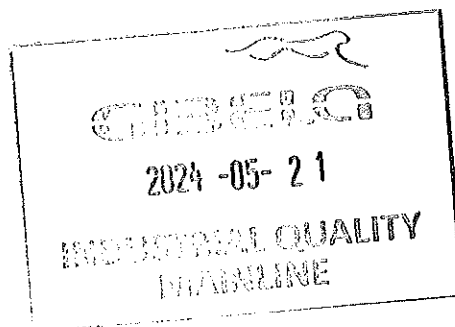
SEALANT APPLICATION




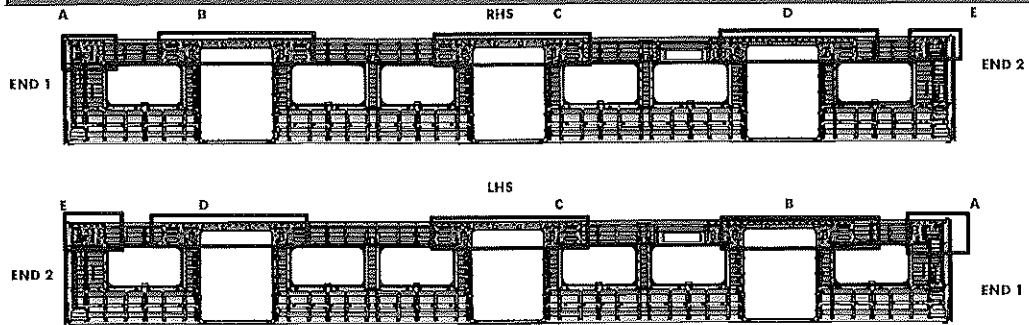
AREA 1 & 2 END 1

Operator (Name & sign):
M. H. Kozari 

Operator (Name & sign):
M. H. Kozari 

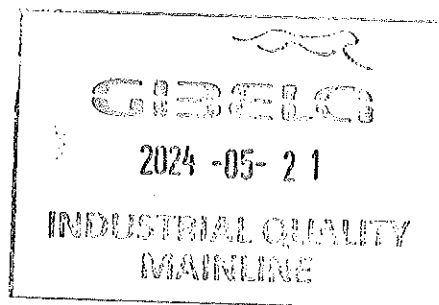



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project PRASA
		29	
		Date	SI.CB1220.276.V29
		28/10/2023	
II - Self Inspection - Items to Check			



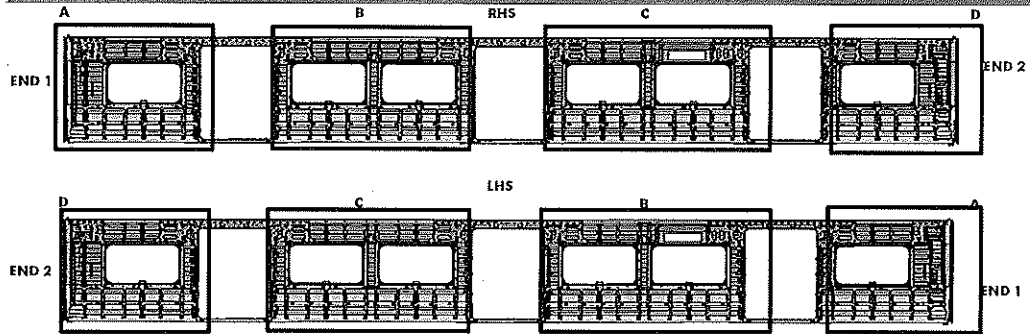
REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDO</u>	<u>[Signature]</u>
B	Operator (Name&sign): <u>LINDO</u>	<u>[Signature]</u>
C	Operator (Name&sign): <u>[Signature] / LINDO</u>	<u>M. MATSUELO</u> / <u>[Signature]</u>
D	Operator (Name&sign): <u>[Signature]</u>	<u>M. MATSUELO</u>
E	Operator (Name&sign): <u>[Signature]</u>	<u>M. MATSUELO</u>

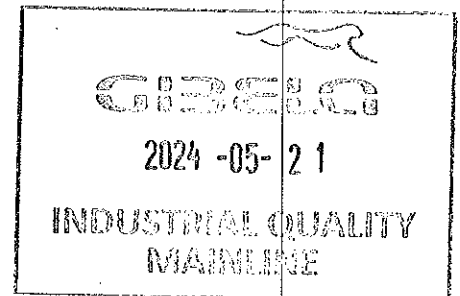


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	


II - Self Inspection - Items to Check



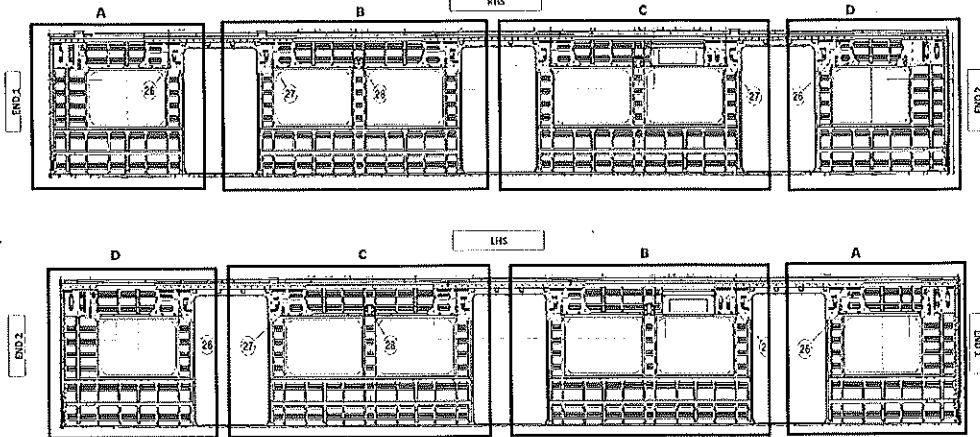
BRACKETING	
INSTALLATION	
C-RAILS:	Operator: <u>Leni</u>
	Operator: <u>Priscilla</u>
DOOR MECHANISMS:	Operator: <u>Priscilla</u>
	Operator: <u>Priscilla</u>
TAPPING PADS	Operator: <u>Priscilla</u>
	Operator: <u>Priscilla</u>
INSTALLATION & VERIFICATION	
SEAT & LUGGAGE BRACKETS:	Operator: <u>Tetelo</u>
	Operator: <u>Tetelo</u>
SEAT BRACKETS VERIFICATION:	Operator: <u>Tetelo</u>
	Operator: <u>Tetelo</u>
WELDING	
AREA	LHS
A (Seat brackets)	: Operator (Name&sign): <u>Xulu</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>LINDO</u>
B (Seat brackets)	: Operator (Name&sign): <u>LINDO</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>LINDO</u>
C (Seat brackets)	: Operator (Name&sign): <u>LINDO</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>LINDO</u>
D (Seat brackets)	: Operator (Name&sign): <u>THULANI</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>THULANI</u>
ENDS	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>LINDO</u>
END 2 TAPPING PADS WELDING:	Operator (Name&sign): <u>THULANI</u>



Xulu
Xulu
LINDO
LINDO
LINDO
LINDO
THULANI
THULANI

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 28	Project: PRASA SI.CB1220.276.V29
		Date 28/10/2023	

M2 BRACKET INSTALLATION



QUANTITIES (M2)

RHS					
	SECTION	QUANTITY	OK	NOX	
C-RAILS	A	8	✓		
	B	8	✓		
	C	6	✓		
	D	2	✓		
SEAT BRACKETS	A	13	✓		
	B	21	✓		
	C	21	✓		
	D	13	✓		
EARTH BUSH	A	2	✓		
	B	4	✓		
	C	6	✓		
	D	3	✓		

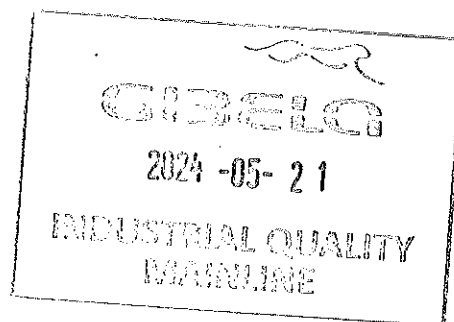
ROOF ENDS:
 C-RAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Teelo

LHS					
	SECTION	QUANTITY	OK	NOX	
C-RAILS	A	9	✓		
	B	11	✓		
	C	11	✓		
	D	12	✓		
SEAT BRACKETS	A	12	✓		
	B	21	✓		
	C	21	✓		
	D	13	✓		
EARTH BUSH	A	3	✓		
	B	7	✓		
	C	6	✓		
	D	2	✓		

ROOF ENDS:
 C-RAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Teelo

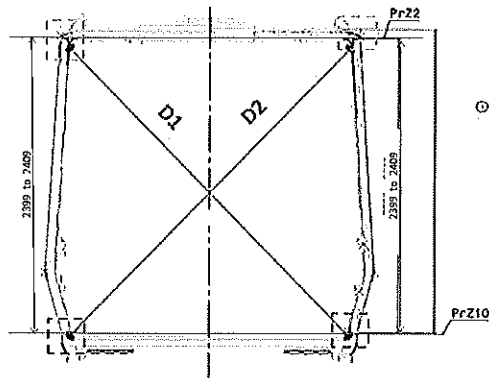




CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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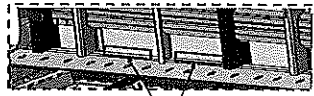
Project: PRASA
SI.CB1220.276.V29



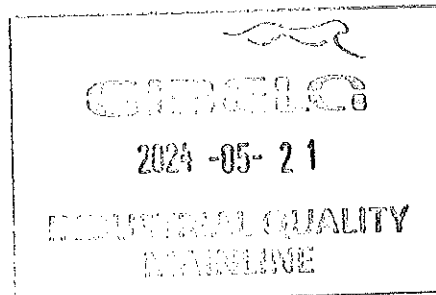
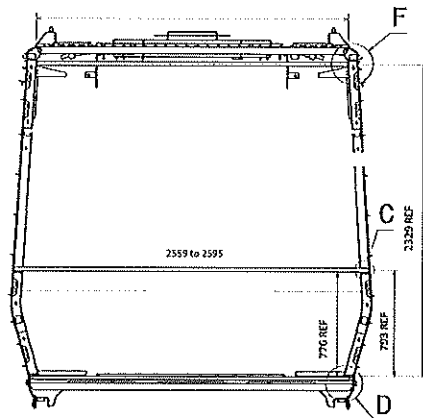
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



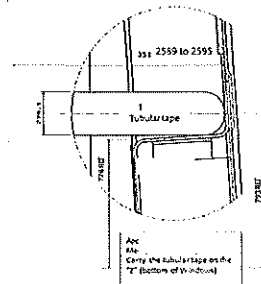
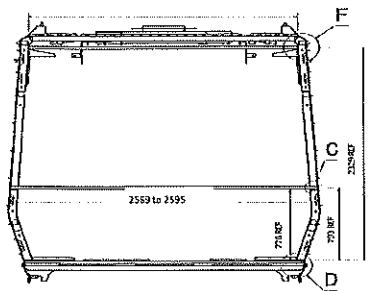


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

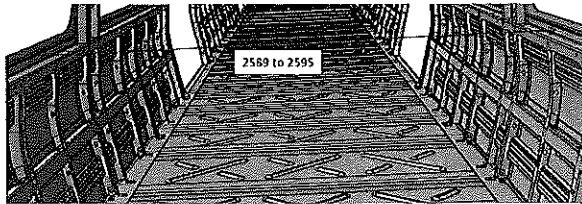
Rev.
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Date
28/10/2023

Project PRASA

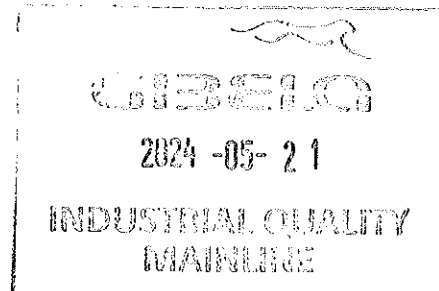
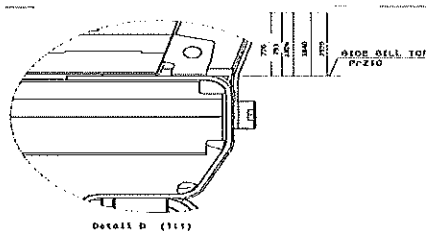
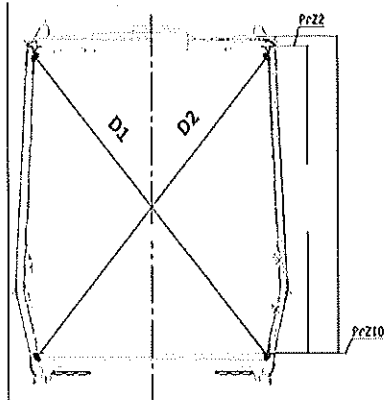
SI.CB1220.276.V29



Detail C



Take measurement close to
radius





CARBODYSHELL M2 ASSEMBLY DTR31374497/2

Rev.

28

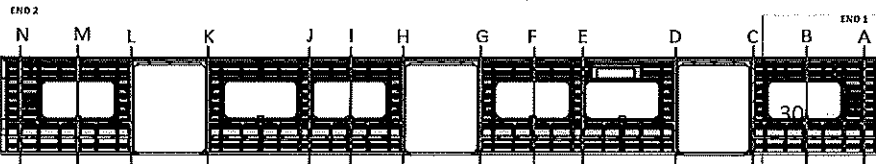
Date

28/10/2023

Project: PRASA

SI.CB1220.276.V29

CBS measurement



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3297	3299	2	
B	3268	3265	3	
C	3300	3297	3	
D	3300	3299	1	
E	3265	3266	1	
F	3267	3268	1	
G	3299	3297	2	
H	3300	3299	1	
I	3269	3267	2	
J	3265	3267	2	
K	3299	3297	2	
L	3300	3295	4	
M	3265	3267	2	
N	3299	3297	2	

N/A

25

20

15

10

5

0


CB1210

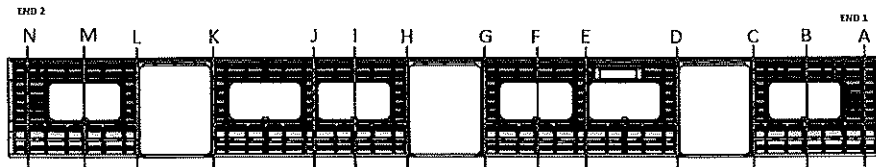
■ Welding / Brazing ■

GIBELQ

2024-05-21

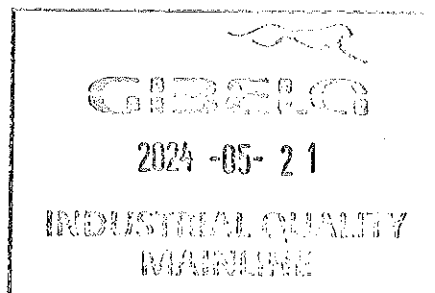
INDUSTRIAL QUALITY
MAINLINE

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	
CBS measurement			



AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3298	2	2590
B	3267	3265	2	2591
C	3300	3298	2	2590
D	3297	3295	2	2592
E	3268	3266	2	2590
F	3267	3266	1	2591
G	3297	3296	1	2590
H	3298	3300	2	2590
I	3265	3267	2	2591
J	3267	3268	1	2590
K	3300	3296	4	2591
L	3297	3295	2	2590
M	3265	3267	2	2591
N	3296	3298	2	2590





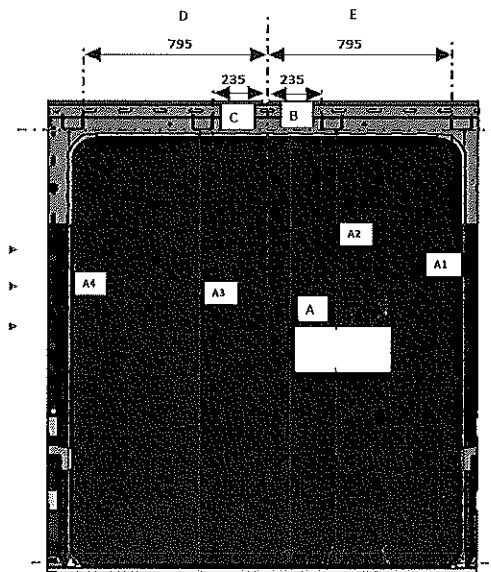
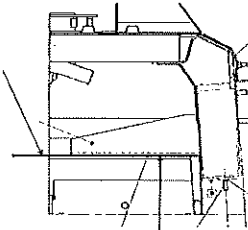
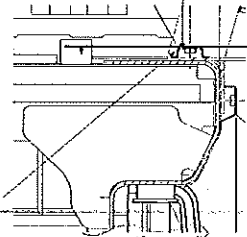
CARBODYSHELL M2 ASSEMBLY DTR3137449712

Rev.
28
Date
28/10/2023

Project: PRASA

SI.CB1220.276.V29

Specifications of Details for CB5 measurement CB1220

Brackets Carbodyshe
U Type SupportsBrackets Carbodyshe
Channel Assy

GIBEL

2024-05-21

DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2230
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	234
D	794 to 796	795
E	794 to 796	795

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	236
C	234 to 236	236
D	794 to 796	795
E	794 to 796	796

DOOR 3 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2230
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	796

DOOR 1 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2230
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	795

DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2232
B	234 to 236	234
C	234 to 236	235
D	794 to 796	796
E	794 to 796	796

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2230
B	234 to 236	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	796



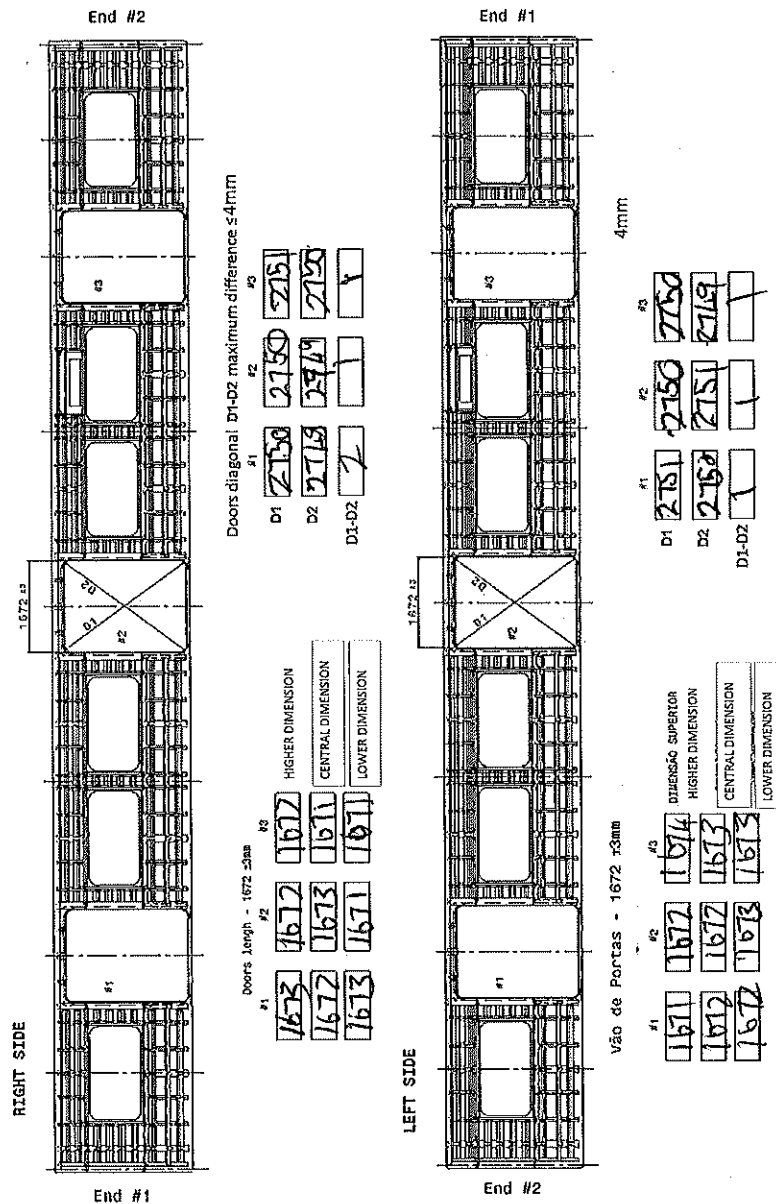
CARBODYSHELL M2 ASSEMBLY DTR31374497/2

Rev.
28
Date
28/10/2023

Project: PRASA

SI.CB1220.276.V29


Specifications of Details for CBS measurement CB1220



GIBELQ

2024-05-21


INDUSTRIAL QUALITY
MAINLINE

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA		
		29			
		Date	SI.CB1220.276.V29		
		20/10/2023			

CBS measurement (Manufacturing)

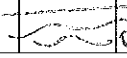
Dye penetrant test

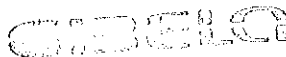
Dye-penetration test to be performed by quality personnel



Item	Description of the Issue	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)

IL2 - Check List REX




Check List Items							
Item	Picture/Drawing	Description	Criteria Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX				

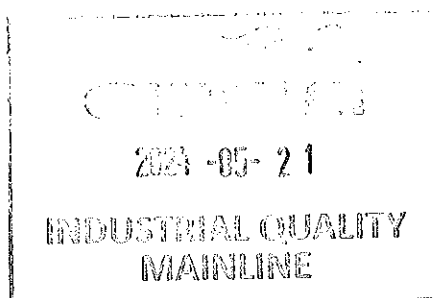



2024-05-21

INDUSTRIAL QUALITY

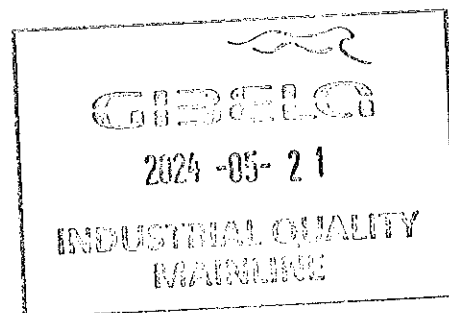
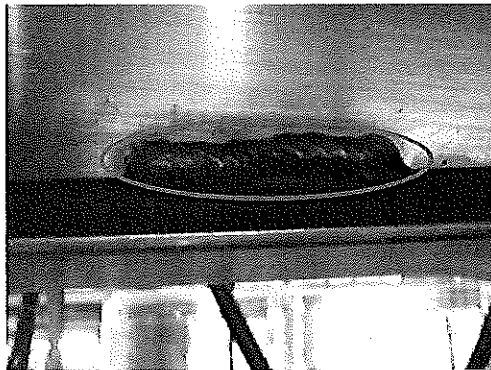
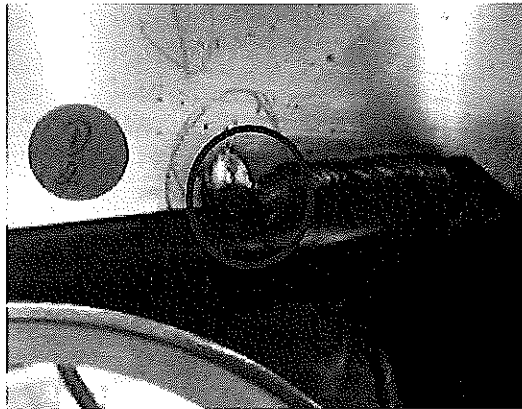
MANLINE

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA			
		26				
		Date	SI.CB1220.276.V29			
		28/10/2023				
Self Inspection - Final Result						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE		
HOLD POINT	✓	GO	(If activities are not complete, the missing activities must not impact the next stage!)	21/05/24	Tetelo	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	21/05/24	Ano	
	✓		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)			
In case of "NO GO", describe blocking problems						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description		Responsible	Due date	Status	
<div style="display: flex; justify-content: space-around;"> <div>Operations</div> <div>Quality</div> </div>						



 GIBELQ	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		29	
		Date	
		28/10/2023	
		SI.CB1220.276.V29	

ANNEXURE A: Arc Welding Quality Acceptance Standard



GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1


SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION

This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

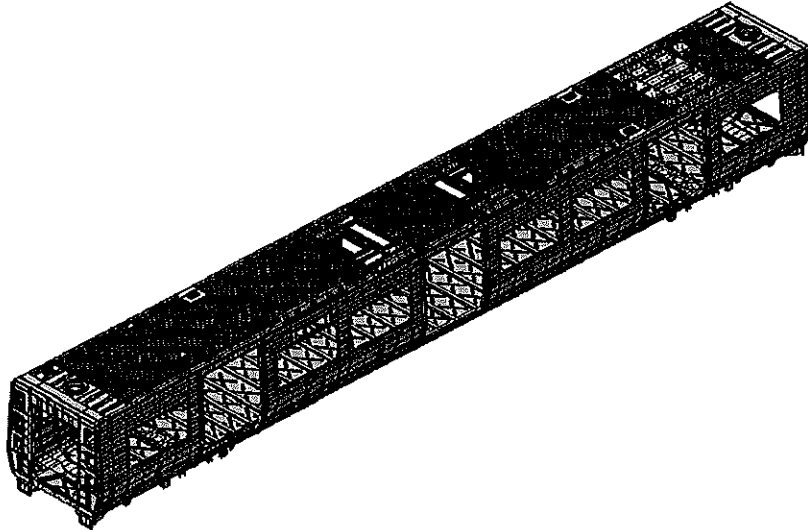
APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?	
				TCa	MA	MA	M2	MA	TCa			
<input type="checkbox"/>	DIR3000152710	AAD0001413329	CARBODY SHELL M2 ASSEMBLY	CB1230				X			PRA.CB1230.AA000013 74497.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE							
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe Marques	2018/08/02							
			CHECKER	Nosizo Pindela	2018/08/02							
			COMPILER	Nosizo Pindela	2018/08/02							
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018							
			CHECKER	Nosizo Pindela	30/5/2018							
			REVISED BY	Nosizo Pindela	30/5/2018							
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07							
			CHECKER	Nosizo Pindela	2018/05/07							
			REVISED BY	Ramokone Motama	2018/05/07							
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019							
			CHECKER	Nosizo Pindela	24/01/2019							
			REVISED BY	Vanessa Ntuli	24/01/2019							
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019							
			CHECKER	Nosizo Pindela	13/03/2019							
			REVISED BY	Vanessa Ntuli	13/03/2019							
10	23/03/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/03/2019							
			CHECKER	Nosizo Pindela	23/03/2019							
			REVISED BY	Nosizo Pindela	23/03/2019							
1	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020							
			CHECKER	Bongane Masina								
			REVISED BY	Bongane Masina								
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021							
			CHECKER	Bongane Masina								
			REVISED BY	Bongane Masina								
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbombhli	20/02/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbombhli	14/06/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
27	26/07/2022	Threshold measurement addition	APPROVER	Collins Mbombhli	27/07/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbombhli	17/10/2022							
			CHECKER	Ntokozo Zwane								
			REVISED BY	Amogelang Mohlampe								
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023							
			CHECKER	Ntokozo Zwane								
			REVISED BY	Amogelang Mohlampe								
30	06/11/2023	Added traceability on thresholds for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023							
			CHECKER	Andani Muthelo								
			REVISED BY	Ntokozo Zwane								
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES							
2256	m 2	Ntshabane 9 127423	22/05/24	SI.CB1230.277.V29	11							

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date 06/11/2023	
Car:	NCR:	Work station: CB1230	

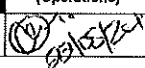
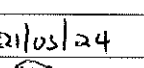


Safety Related



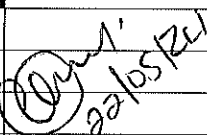
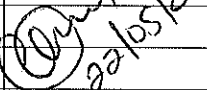

I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	N/A	Signature/Date (Operations)	Signature/Date (Quality)
	TC	M1	M2	M3	M4	TC2							
PRA.CB1230.AA00001374497							30		✓		N/A	 21/03/24	 21/03/24

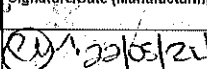

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	12062-2	2025/02/19	✓		 21/03/24	21/03/24
Combination Square	GIB-50082	2025/03/20	✓		 21/03/24	
Measuring Tape	GIBTP0006	2024/07/19	✓			

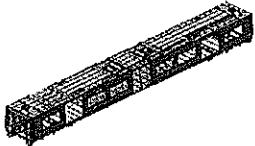
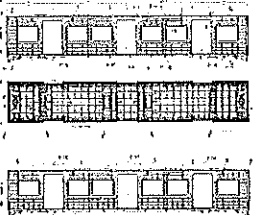
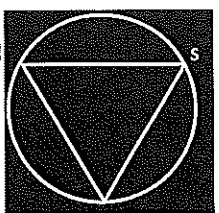
1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSI	E231007	MIG	✓		 21/03/24	21/03/24
						

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.AA00001374497 Verification of fitment for all brackets.	PRA.CB1230.AA00001374497	✓	Tham 22/08/24	
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	Tham 22/08/24	
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	Tham 22/08/24	
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	Tham 22/08/24	
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	Tham 22/08/24	
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS 018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓	Tham 22/08/24	
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (1) Min-Max 10°C - 35°C Relative humidity, Min - Max (1) Min-Max 25% - 80%	Sealant Batch No: 105313 Exp Date: 04 June 2025 Actuals Temperature: 18°C Humidity: 62%	✓	Tham 22/08/24	
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	✓	Tham 22/08/24	



CARBODYSHELL M2 ASSEMBLY AA00001374497

Rev.

30

Date

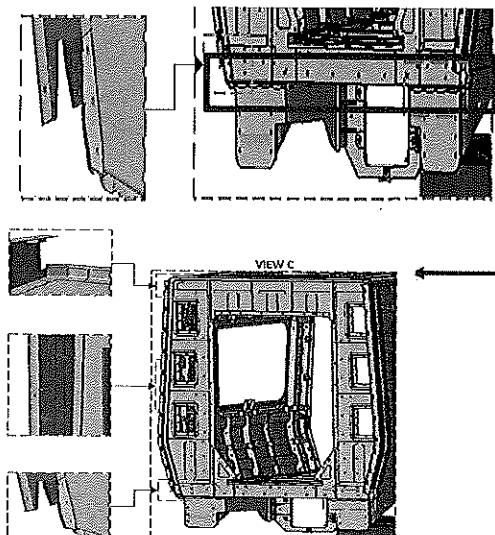
06/11/2023

Project: PRASA

SI.CB1230.277.V29

END 2 SEALANT

AREA 1



OPERATOR
(Name & sign):

Ceroy

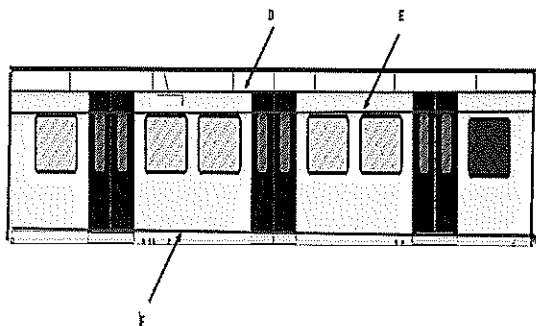
OPERATOR
(Name & sign):

Ceroy

OPERATOR
(Name & sign):

Ceroy

H



Area D,E,F,G,H,I

Operator (Name & sign) :

LHS

D, E, G, H, I

RHS

D, E, G, H, I

Operator (Name & sign) :

Bunle

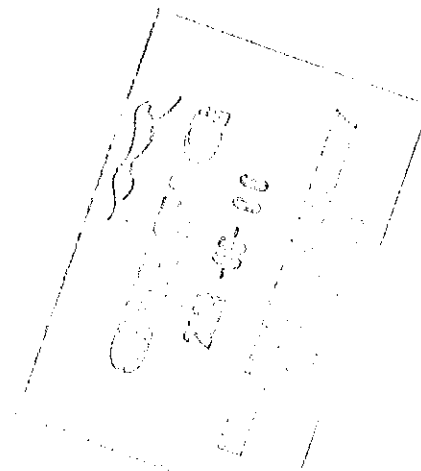
Operator (Name & sign) :

Boily

Operator (Name & sign) :

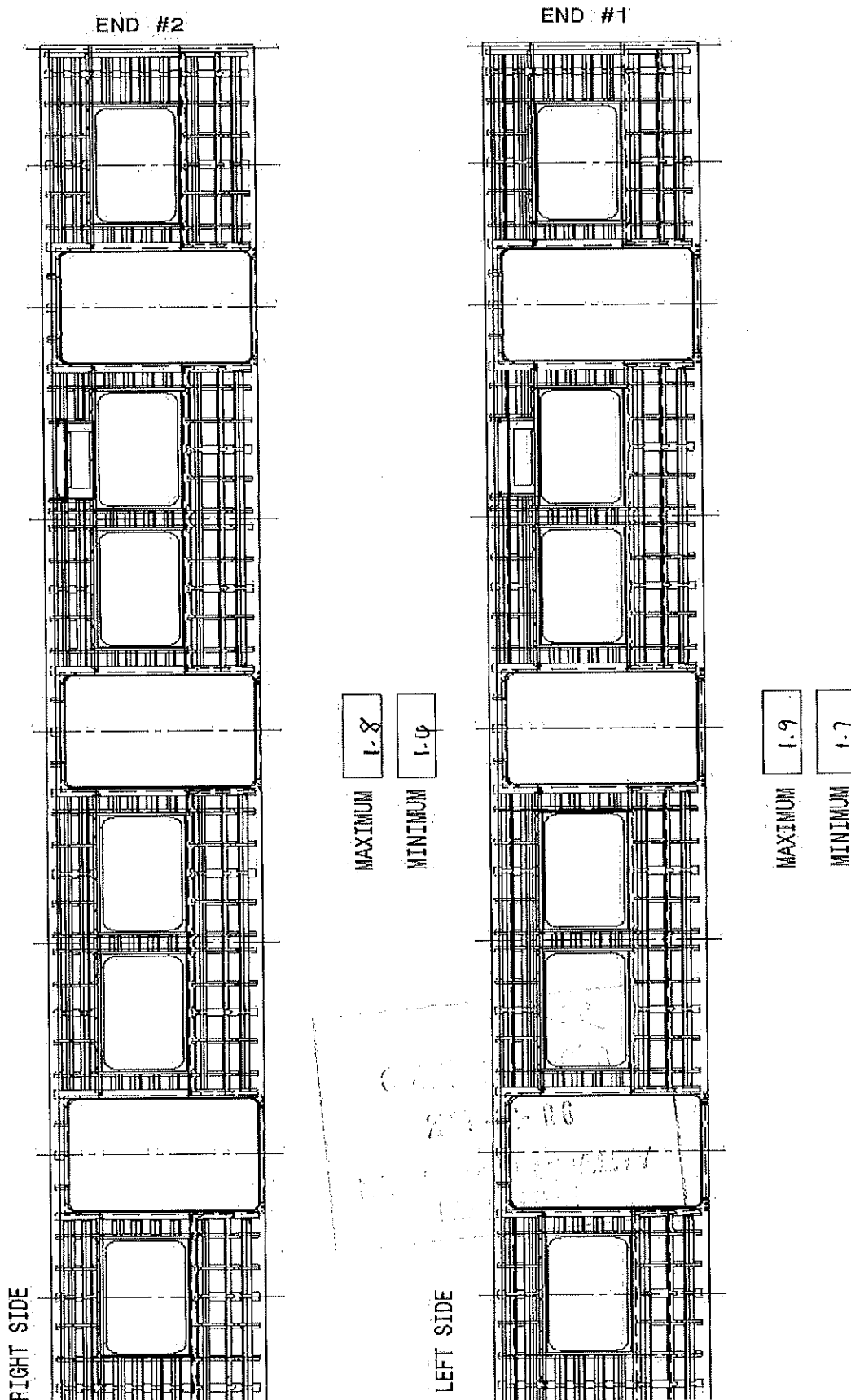
Operator (Name & sign) :


Operator (Name & sign) :



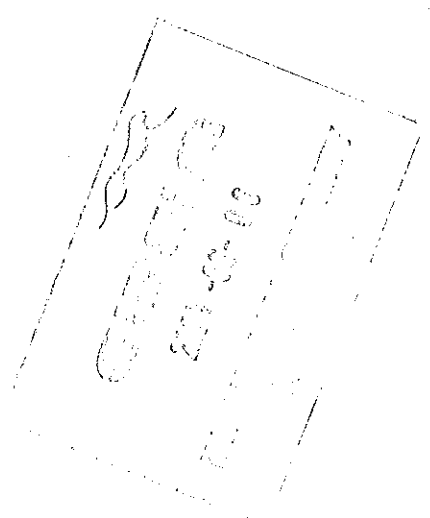
Specifications of Details for CBS measurement CB1230

latness side left and right maximum of 2mm in the valley to peak measured in 900mm. Record the maximum and minimum value found and indicate the corresponding region.



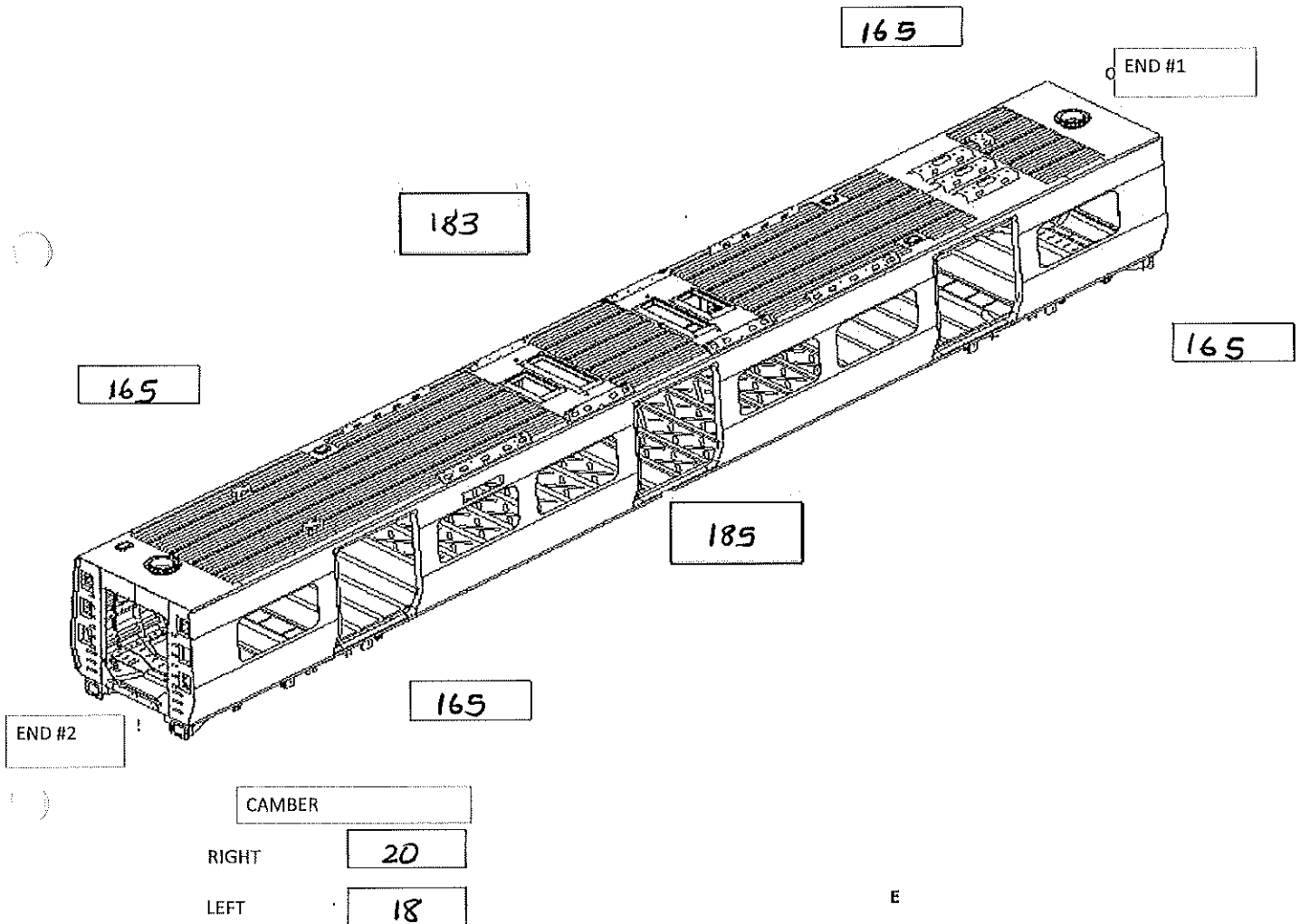
	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date 06/11/2023	

LL		
	END #1	END #2



Specifications of Details for CBS measurement CB1230

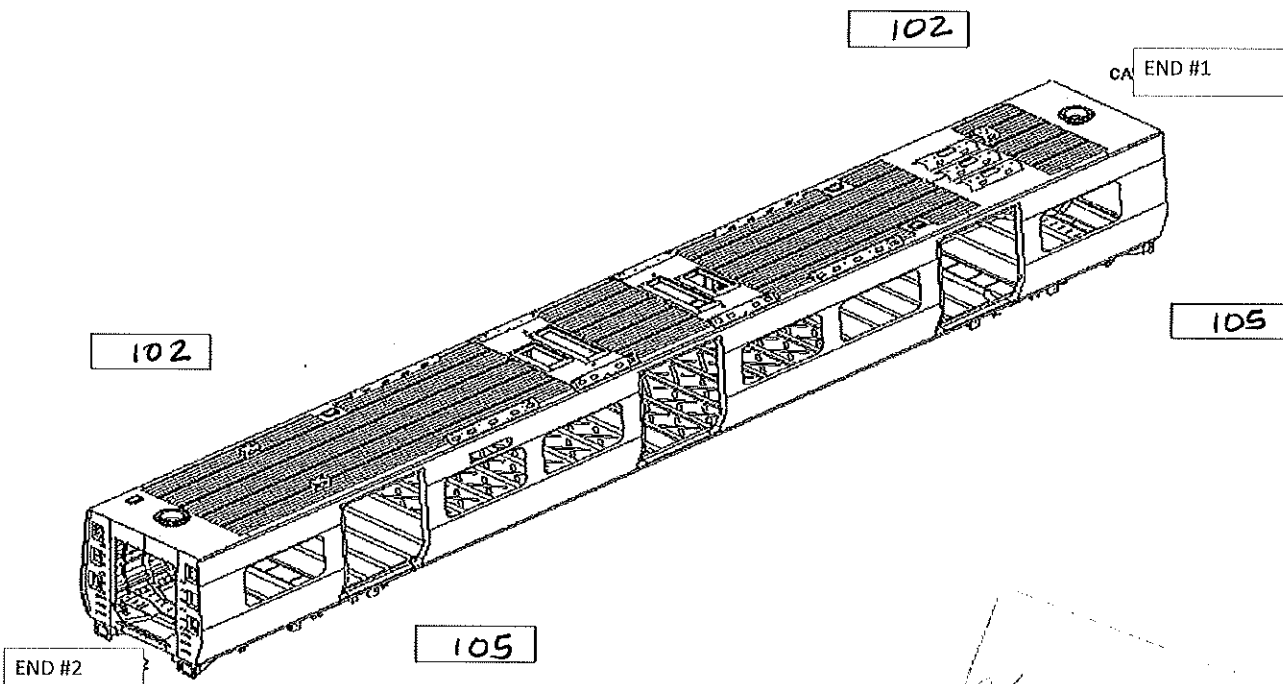
Specified Camber for car out of jig is 18mm(-0mm + 2mm)



2023-06-11
2023-06-11
2023-06-11
2023-06-11
2023-06-11

Specifications of Details for CBS measurement CB1230

Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 following twist measurement document.



TWIST FOUND ON END 1

TRANVERSE

3

LONGITUDINAL

0

TWIST FOUND ON END 2

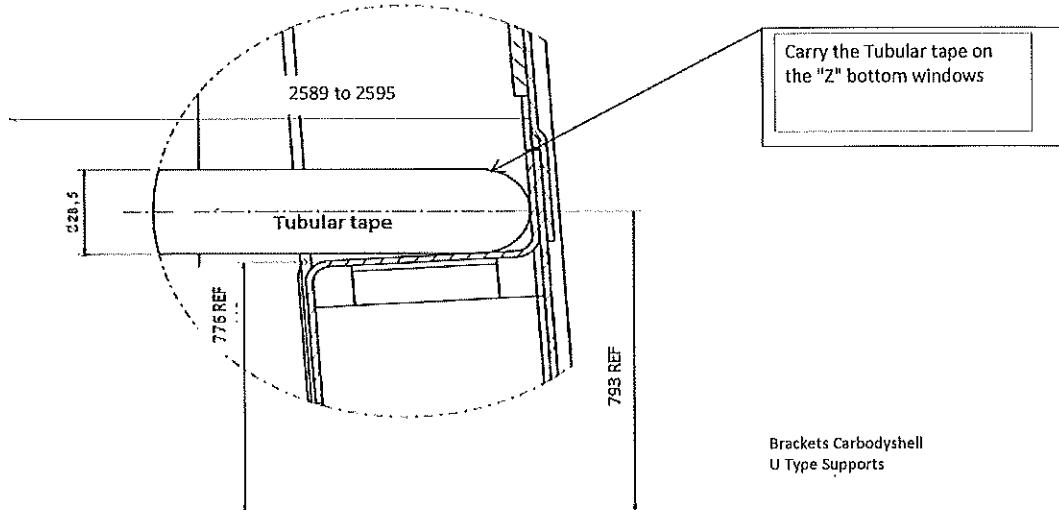
TRANVERSE

3

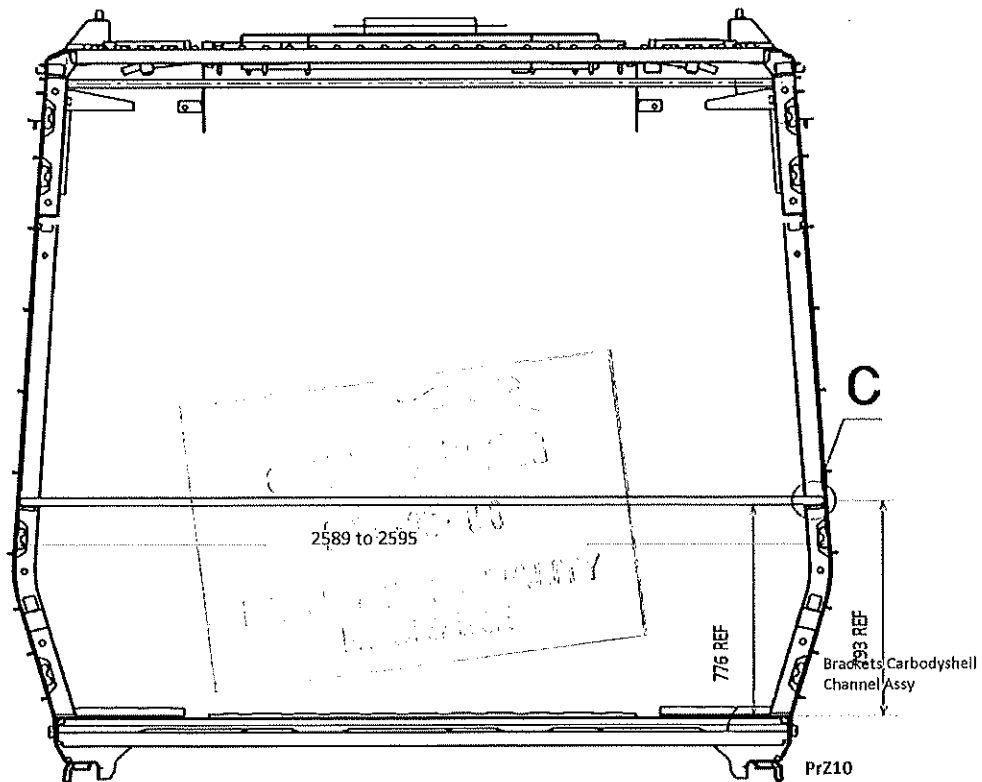
LONGITUDINAL

0

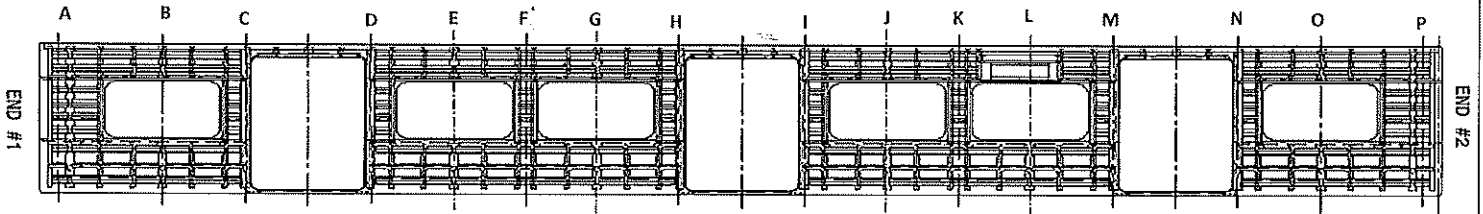
Specifications of Details for CBS measurement CB1230



Detail C

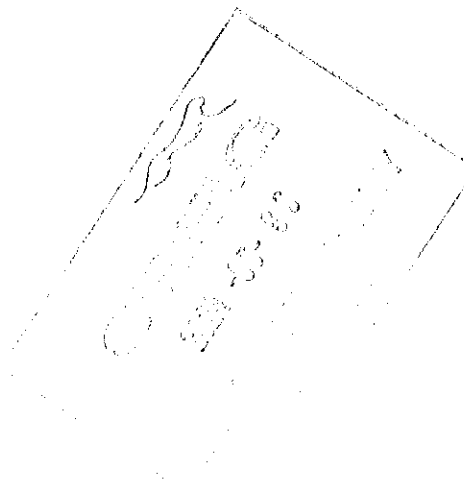
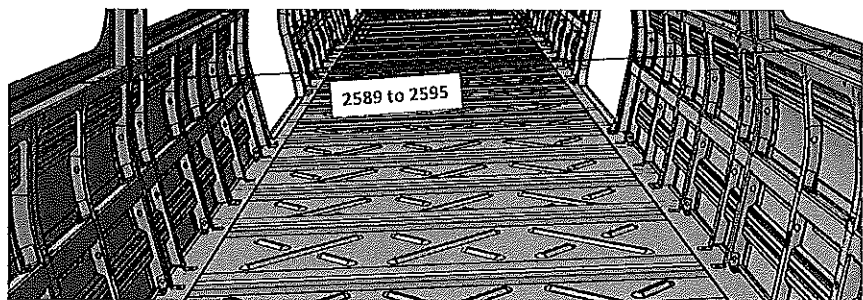


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2590
B	2592
C	2595
D	2591
E	2590
F	2592
G	2593
H	2594
I	2590
J	2594
K	2593
L	2594
M	2595
N	2594
O	2591
P	2593



Threshold verification						Nominal value :38	
Door 1		Door 2		Door 3			
L	R	L	R	L	R		
36	36	37	37	36	37		
Door 4		Door 5		Door 6			
L	R	L	R	L	R		
37	37	36	37	36	36		


BOILER MAKER:

Kgotsi


WELDER:

Marathapelo

Mokhele

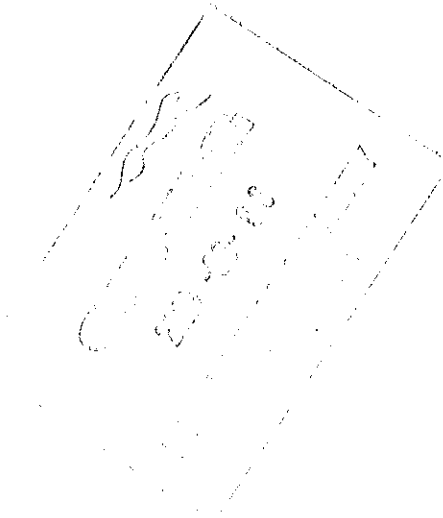
	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA
		Date 06/11/2023	
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2023-07-08
F. HALLBY
L. HALLBY

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date	
		06/11/2023	

Dye penetrant test

Dye-penetration test to be performed by quality personnel



06/11/2023

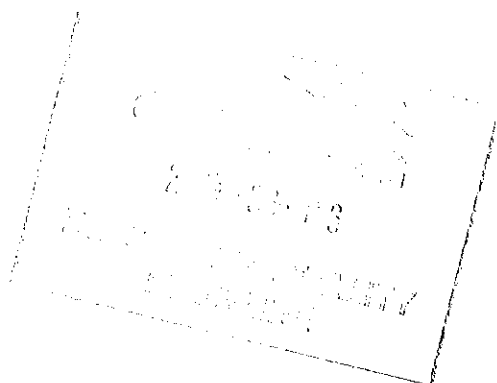
Specifications of Details for CBS measurement


[illegible]

11.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK	REX	Remarks	Signature/Date (Operations)	Signature/Date (Quality)
Q1	N/A	To complete REX	Refer to REX. New defects must be added on the REX					



	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date 06/11/2023	

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)		22/05/24 <i>[Signature]</i>	<i>Montblanck</i> Operations	<i>[Signature]</i>
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)		22/05/24	<i>Richmond</i> Industrial Quality	<i>[Signature]</i>
	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality	

In case of "NO GO", describe blocking problems

In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description		Responsible	Due date	Status

Operations

Quality

